







Date: Monday, 27/04/2009 12:50:55 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 47521	
Estimate Number : 12736	
P.O. Number :	Part Number : D353515 GY
This Issue : 27/04/2009 S.O. No. :	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 42249	Material :
Written By :	Due Date : 07/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09.04.27</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
1.0	M304S20GA 304/316 .040 Sheet
	
Comment: Qty.: 1.0715 sf(s)/Unit Total: 10.7153 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: <u>11571</u> <u>189-5-20</u>	
2.0	WATER JET FLOW WATER JET
	
Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: <u>B</u> <u>189-5-20</u> (13) Prog Rev: <u>B</u> 2-Deburr if necessary <u>189-5-20</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>189-5-20</u>	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>809/05/20</u> (13)	
5.0	BRAKE NC NC BRAKE
	
Comment: NC BRAKE 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15 <u>SB 09/05/22</u> (13)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 12:50:55 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 47521

Part Number: D353515

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/02 (X13)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:45am

OVEN TEMPERATURE:

320°C

FINISH TIME:

9:15am

90

09-05-25

(X13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-25

(13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FR-18

09-05-25

(13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26

Job Completion



MF 09-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47521
Description: Wearshoe		Part Number: D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.886	X			
2.000	+/-0.010	2.001	X			
5.650	+/-0.010	5.650	X			
9.150	+/-0.010	9.150	X			
14.400	+/-0.010	14.400	X			
19.650	+/-0.010	19.650	X			
24.900	+/-0.010	24.900	X			
30.150	+/-0.010	30.150	X			
33.650	+/-0.010	33.650	X			
35.650	+/-0.010	35.650	X			
39.150	+/-0.010	39.150	X			
Ø0.188	+0.005/-0.001	.192	X			
24.00	+/-0.030	24.000	X			
16.00	+/-0.030	16.000	X			
8.00	+/-0.030	8.000	X			
5.00	+/-0.030	5.000	X			
0.300	+/-0.010	.305	X			
0.300	+/-0.010	.303	X			
0.038	+/-0.010	.036	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-5-20	Date: 09/05/26	Date:	N/A

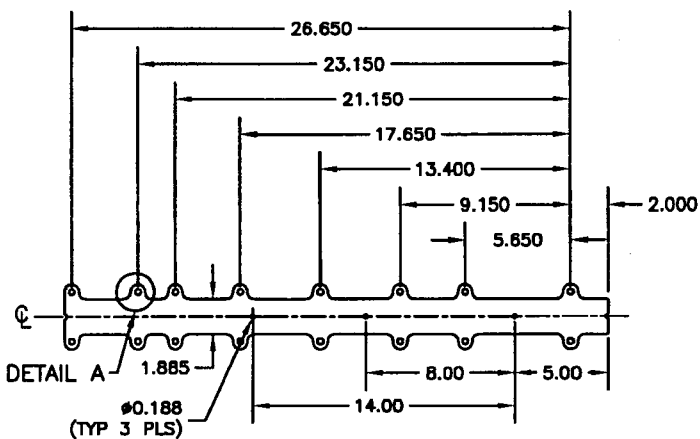
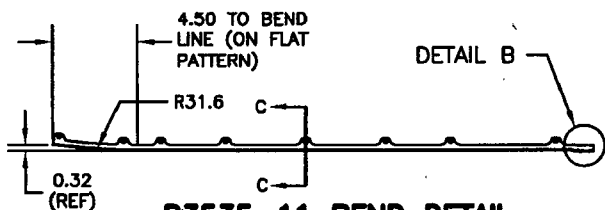
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

DART

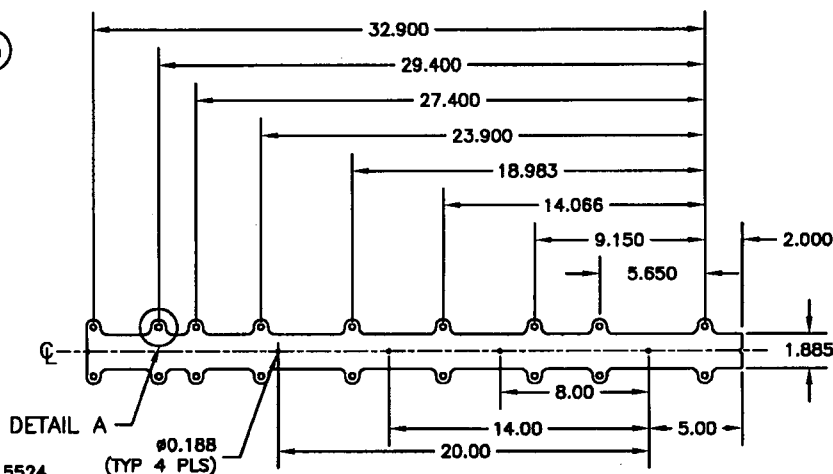
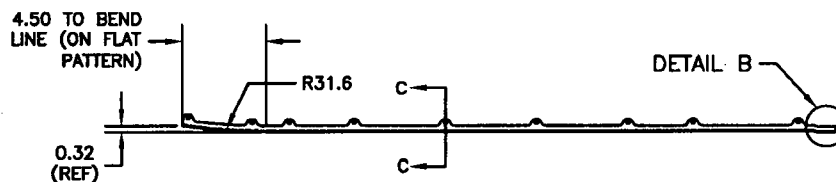
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07.04.24

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CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

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WORK/REWORK
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**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

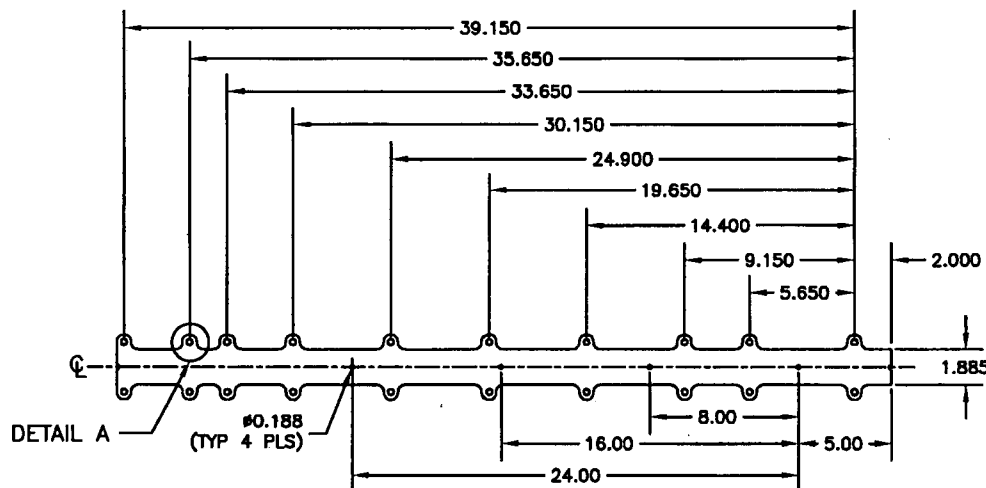
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

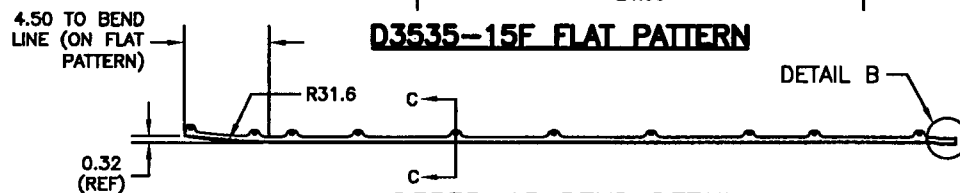
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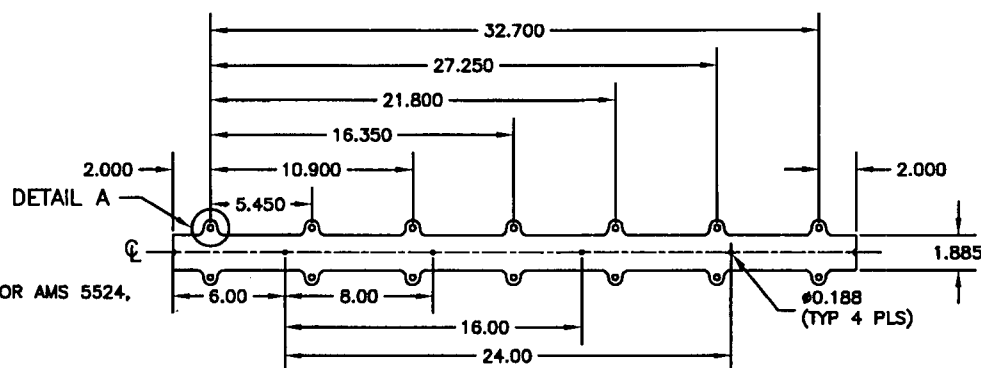
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET 2 OF 7	SCALE	1:10



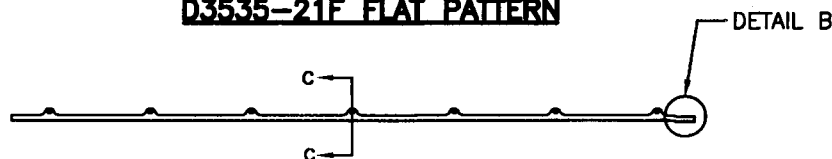
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



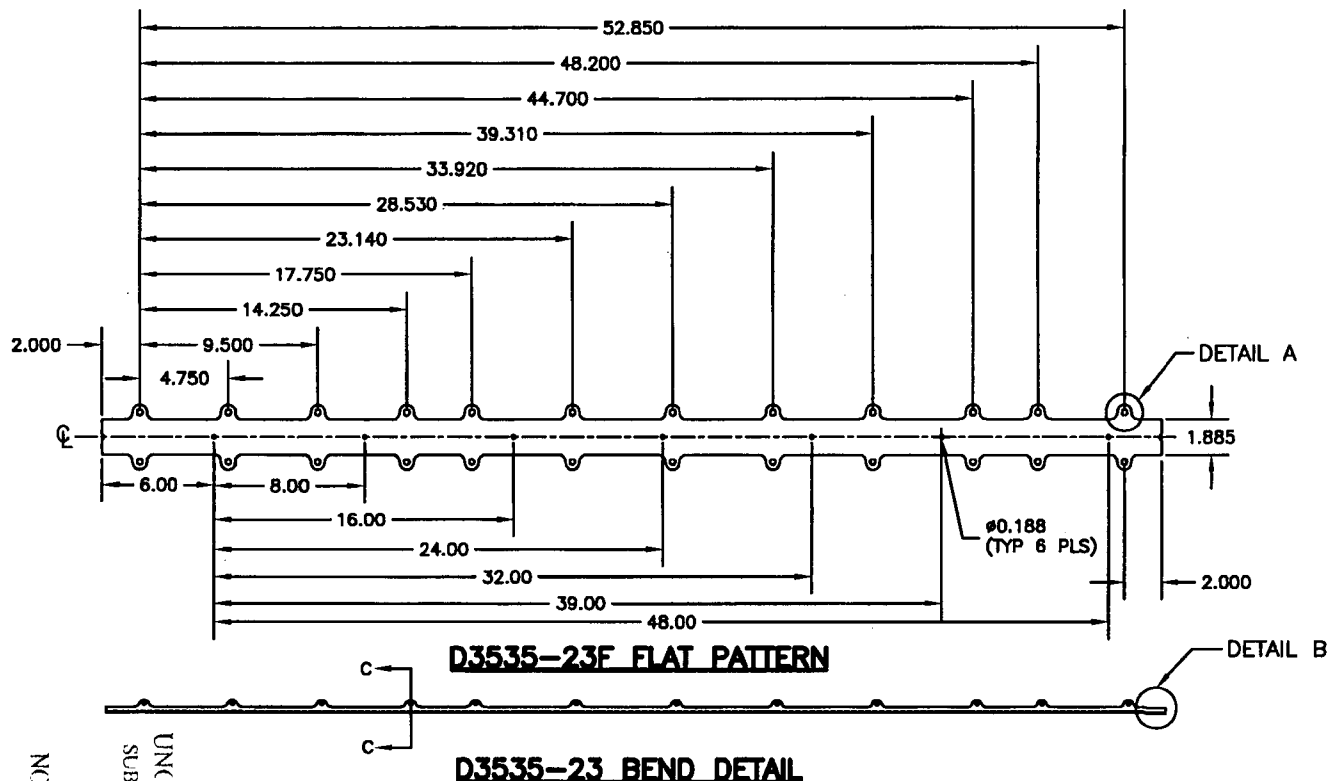
D3535-21 BEND DETAIL

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- WORK ORDER
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- 20 GAUGE (0.038 THICK)
- AMS 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
- 1) MATERIAL:
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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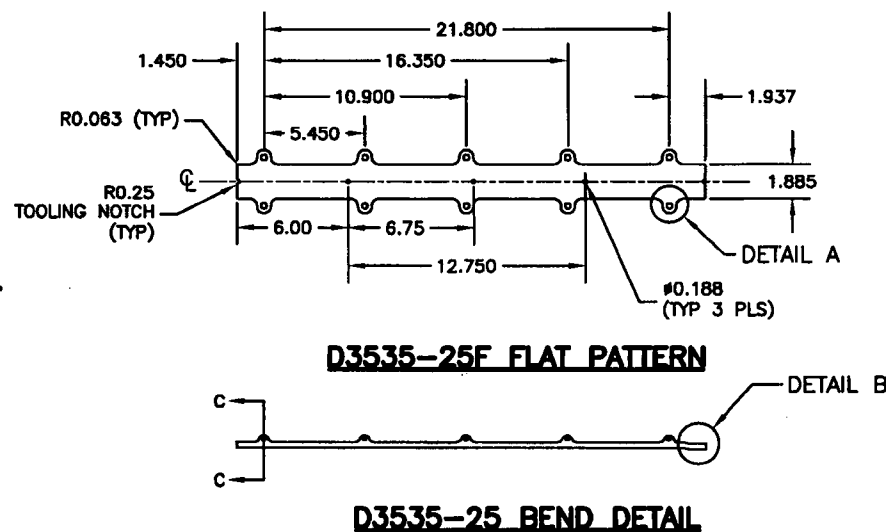
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WORK ORDER
NO. 41501

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
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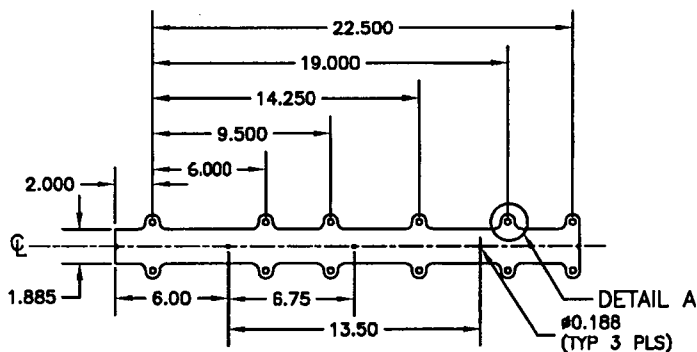


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07.04.17	07.04.17	D3535
DATE	TITLE	SHEET 3 OF 7
07.04.17	WEARSHOE	SCALE 1:10

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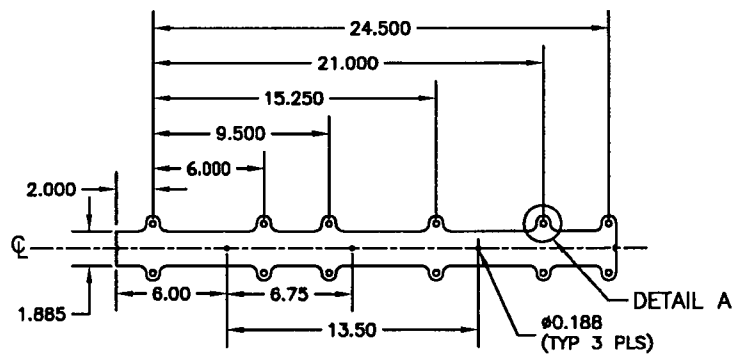
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D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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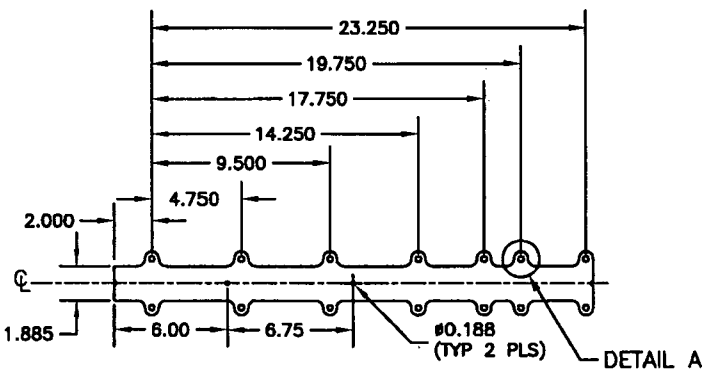
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DATE	TITLE	SCALE	
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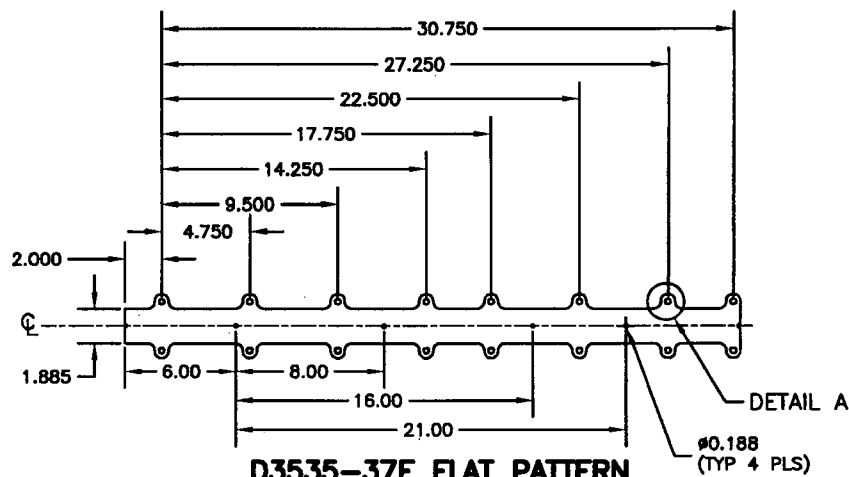
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		D3535	SHEET 5 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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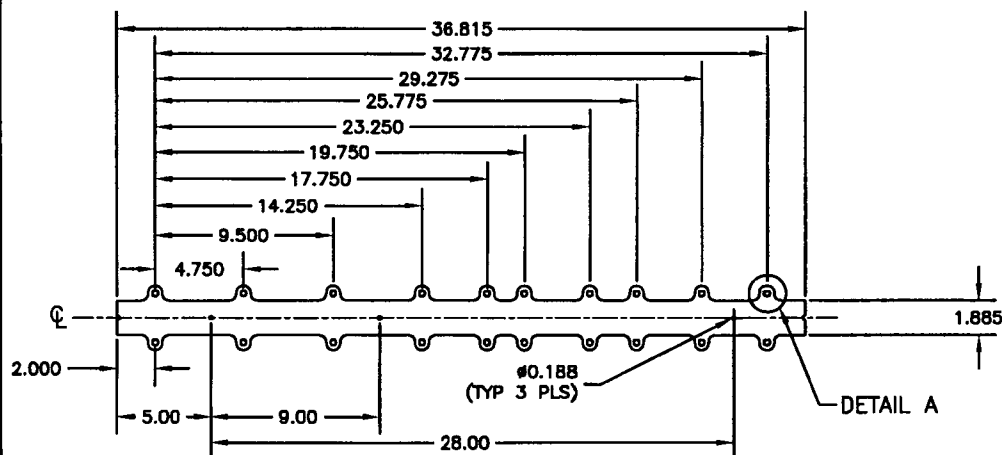
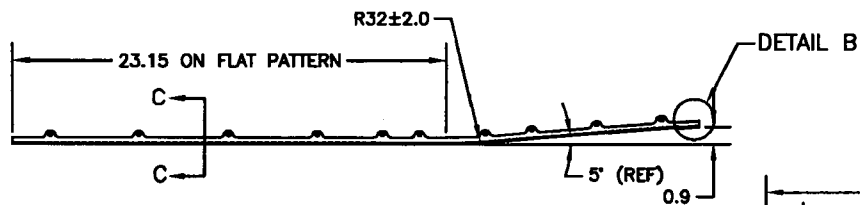
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
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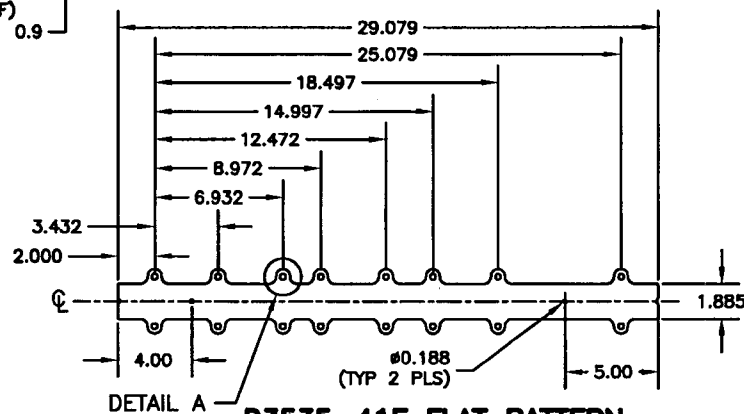
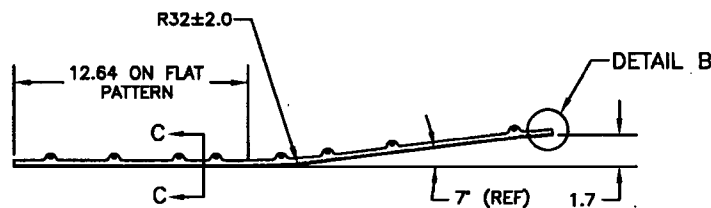
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**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL**

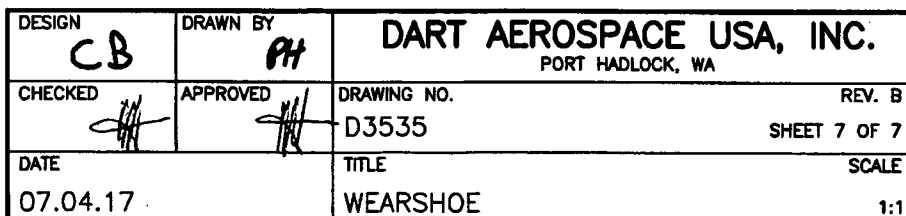
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NOTES

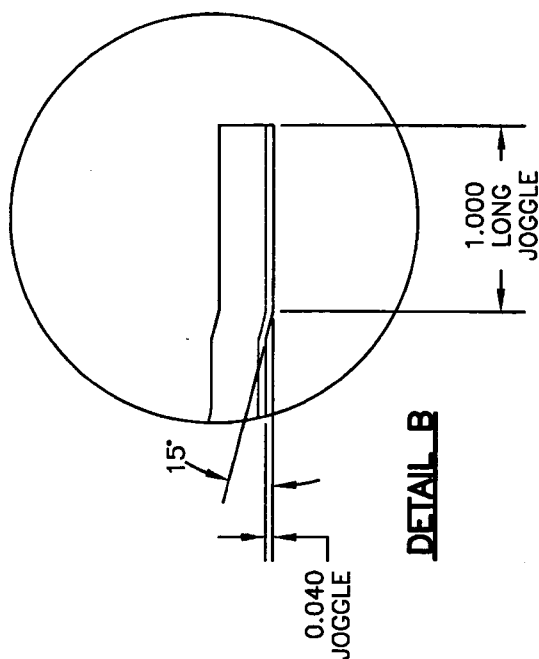
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**D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

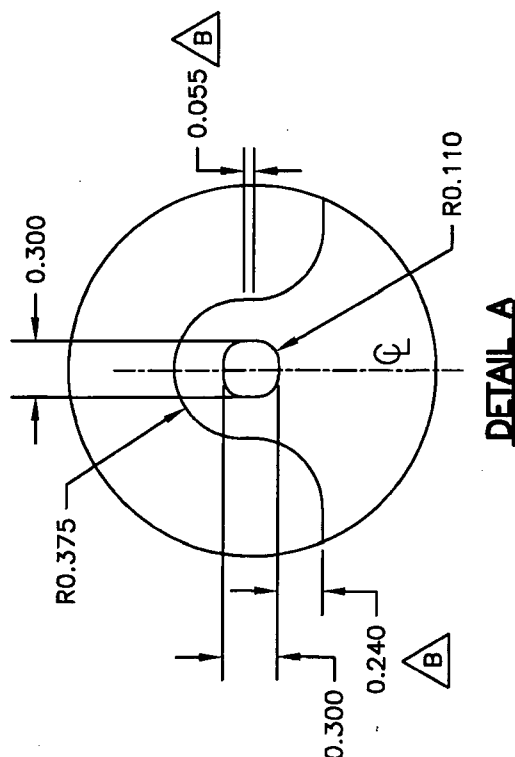
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		REV. B
		SHEET 6 OF 7



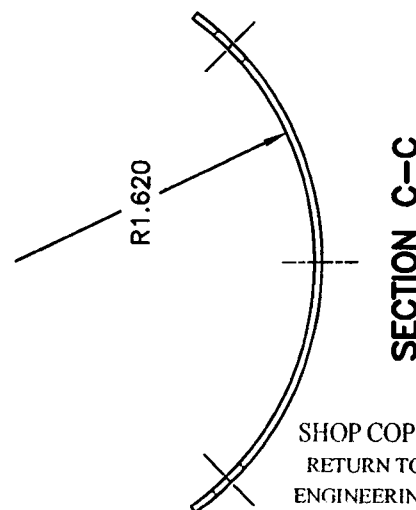
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DETAIL B



DETAIL A



SECTION C-C

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